

Re-Print (MISSING KANBAN) DUPLICATE

Work Order ID 69164



Page 1

Wednesday, May 11, 2011 10:24:04 AM

Item ID: D4016-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half, Lid

Start Date: 5/3/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 8.00



Customer:

Reference:

11-05-11

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4016	A								

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

OK 11/05/17

10

Jeaspa Bandsaw

CUT BLANK as per folio

110

0.00



HAAS I

Memo

0.00

G.A 11/05/17

10

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA874 AND DWG

FOLIO REV: AA

DWG REV: A

DEBURR

Work Order ID 69164

Wednesday, May 11, 2011 10:24:04 AM

Page 2

Item ID: D4016-3

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Revision ID:

Stop

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Start Date: 5/3/2011 Start Qty: 8.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B.A 11/05/17

10

0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

and 11/05/18

10

0

160

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD
11-05-19

10

Work Order ID 69164

Wednesday, May 11, 2011 10:24:04 AM



Page 3

Item ID: D4016-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half, Lid

Start Date: 5/3/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/5/19 *[Signature]*
MF
11-05-19

Picklist Print

Wednesday, May 11, 2011 10:24:01 AM

Page 1

Work Order ID: 69164



Parent Item: D4016-3



Parent Item Name: Hinge Half, Lid

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	12.5440	0.08	0.673684			

304 bar 1.00 x 1.00

Location

Loc Qty

Loc Code

MAT050

12.544

113290

1.047

117130

11.497

800 on 5/10/17

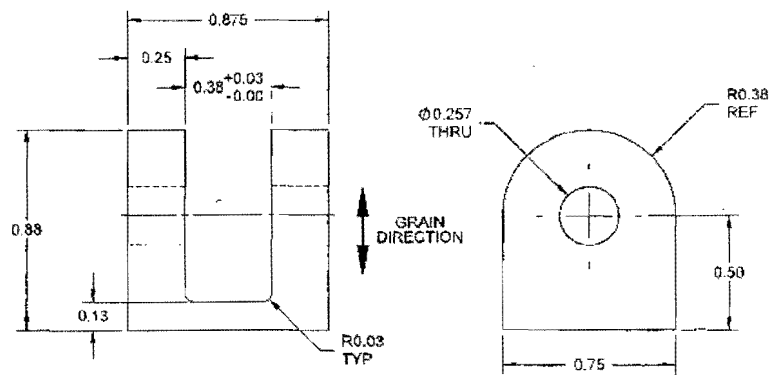
DART AEROSPACE LTD		Work Order: 69164
Description: Hinge Half, Lid		Part Number: D4016-3
Inspection Dwg: D4016 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

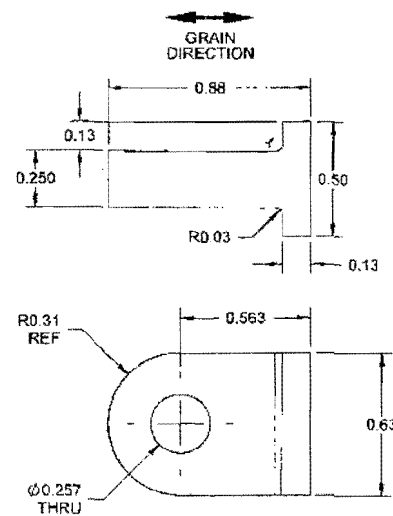
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	0.875	✓		Vern	GA-01
0.13	+/-0.030	0.127	✓		"	"
0.250	+/-0.010	0.251	✓		"	"
R0.03	+/-0.030	R0.030	✓		R-6	ref.
0.13	+/-0.030	0.125	✓		Vern	GA-01
0.50	+/-0.030	0.500	✓		"	"
0.63	+/-0.030	0.625	✓		"	"
0.563	+/-0.010	0.562	✓		"	"
Ø0.257	+0.006/-0.001	Ø0.258	✓		"	"

Measured by: B.A	Audited by: <i>smf</i>	Preliminary Approval:
Date: 11/05/17	Date: 11/05/18	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	<i>[Signature]</i>



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD. ALL RIGHTS RESERVED. NO PART OF THIS DRAWING MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	

w/o 69/601